

Date: Thursday, 11/16/2006 4:25:15 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: FWD X-TUBE	
Job Number	: 29482				
Estimate Number	: 10006				
P.O. Number	: N/A		Part Number	: D2889	
This Issue	: 11/16/2006		Drawing Number	: D2889 REV B	
Prsh Rev.	: NC		Project Number	: N/A	
First Issue	: N/A		Drawing Revision	: B	
Previous Run	: 23963		Material	: N/A	
Written By	: <i>JL</i> 06 11 17		Due Date	: 12/10/2006	
Checked & Approved By			Qty:	1	
Comment	: Est Rev:A New Issue 05-10-25 JLM		Um:	Each	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6005180	Crosstube material
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Crosstube material Pick: Qty Part number Description Batch 1 D2889 Fwd Crosstube <i>28693</i>
2.0	BENDING	BENDING MACHINE
		Comment: LANDING GEAR RESOURCE 1 1-Bend D2889 as per Dwg D2889 and Folio FT001
		<i>EL 7-3-20</i>
3.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
		Comment: LANDING GEAR RESOURCE 1 1-Deburr and Polish
		<i>N/A</i>
4.0	QC6	DIMENSIONAL CHECK
		<i>2004.12 ①</i>
		Comment: DIMENSIONAL CHECK
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		Comment: HAND FINISHING RESOURCE #1 Acid etch and alodine as per QSI 005 4.1 Inside and outside of tube
		<i>N/A</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/14/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

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Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



N/A



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: W1031373

F 0704.12 ①

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

① 0710413

Job Completion



① 07.04.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

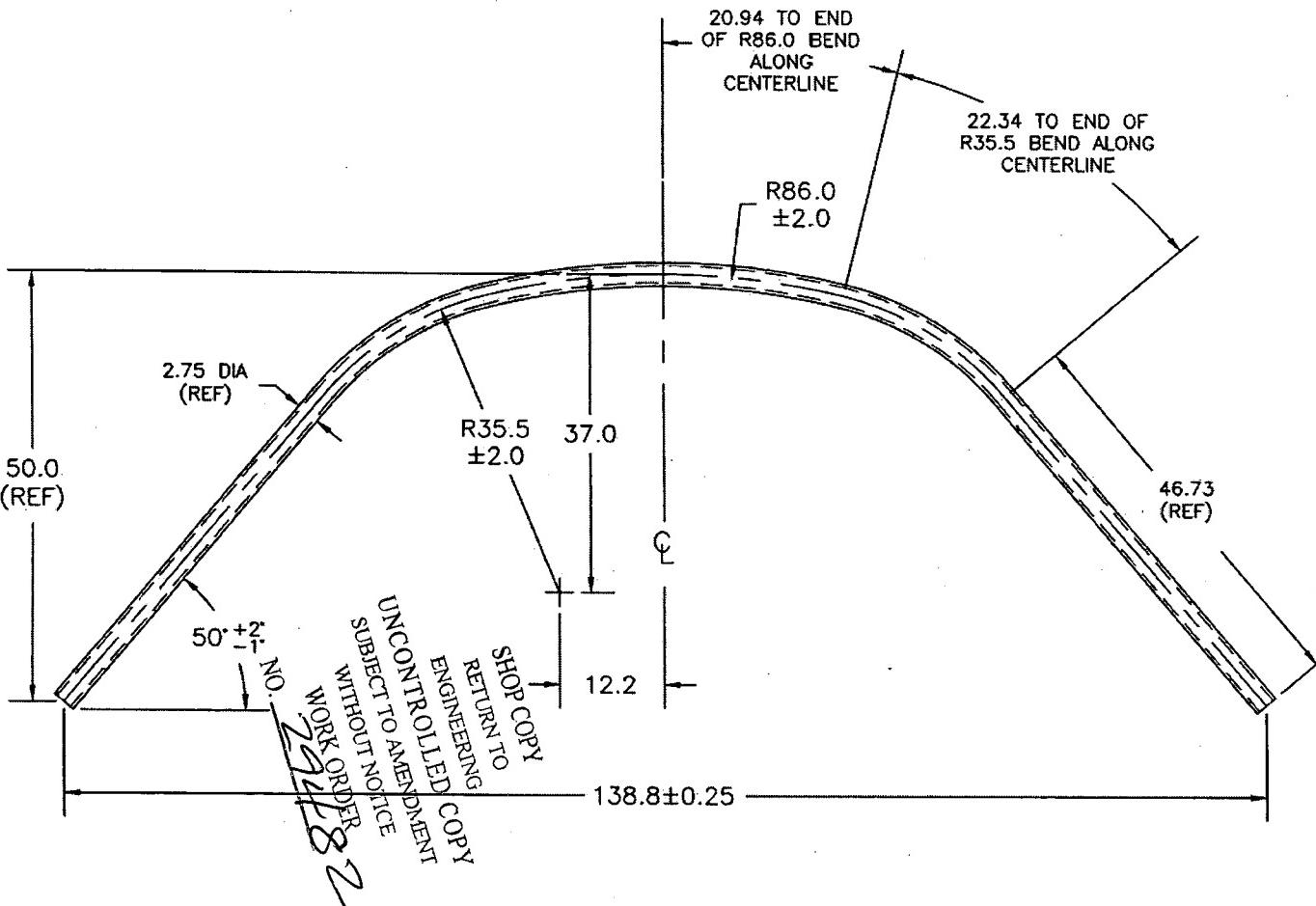
NOTE: Date & initial all entries

DART

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
REV. B
DRAWING NO. D2889
SHEET 1 OF 1
SCALE 1:20

RELEASED
02.10.28

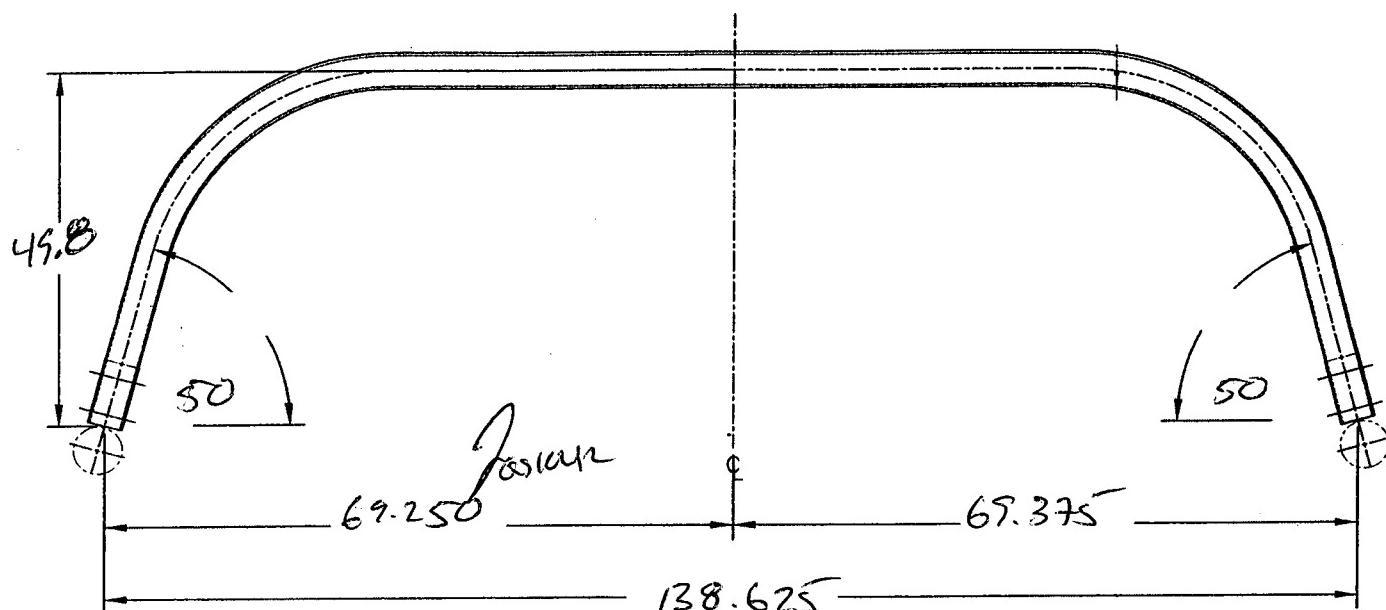
DESIGN	DRAWN BY
	CP
CHECKED	APPROVED
	SH
DATE	TITLE
02.10.18	FWD CROSSTUBE
A	99.05.21 NEW ISSUE
B	02.10.18 ADD TANGENT LENGTHS; CHANGE NOTES

**NOTES**

- 1) MATERIAL: MANUFACTURE FROM D6005-180 ($\phi 2.75$ OD x 0.375 WALL)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BEND PROGRESSIVELY WITH MINIMUM OF 3 PASSES
- 6) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

DART AEROSPACE LTD	Work Order:	29482
Description: Crosstube Fwd	Part Number:	D2889
Inspection Dwg: D2889	Rev: B	Page 1 of 1

Required Dimension	Min	Max
Height	49.875	50.125
1/2 Span	69.275	69.525
Angle	49	52
Total Span	138.55	139.05



Comments
Tube is for W/O 31373 -101

QC15 Inspection	<i>[Signature]</i>
Date	0704-12

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	